Work Order ID 51222

August 11, 2009 9:59:42 AM

ASAP
Ship thurs - Aug. 13th

Item ID: D130-700-011 **Accept** **Setup Start** **Stop**

Revision ID: A

Item Name: Bearpaw

Start Date: 08/11/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 08/13/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** mf **Date:** 09-08-11 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D3167	Rev A1
IIN-D130-700	Rev A

2 = 1

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	DOCUMENT CONTROL	0.00							
DC	**Memo**	0.00							
Document Control	Photocopy bluefile and create labels per PPP D130-700-011CHG001					8 09/08/12			
120	FLOW WATER JET	0.00							
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	Cut Blank as per File D3167-1_BLANK					B 9-8-11			

2 = 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
09/08/12	130	Thickness and chanfer are under tolerance by .100" due to malfunctioning of jig. (No lock-tight on threaded inserts.		I put some red lock-tight on all 6 inserts and the problem is solved	Y.A 09/08/12	N/A	09.08.12	

NOTE: Date & initial all entries

Work Order ID 51222

August 11, 2009 9:59:42 AM

Item ID: D130-700-011 **Accept** **Setup Start** **Stop**

Revision ID: A

Item Name: Bearpaw

Start Date: 08/11/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 08/13/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	HAAS CNC VERTICAL MACHINING #1	0.00				2 = 1			
HAAS 1	**Memo**	0.00							
HAAS CNC vertical machine #1	Note: (2) Bearpaw for (1) Kit 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA285 and Dwg D3167 3-Deburr		Y.A 09/08/11						
140	QC2- Inspect parts off machine FAI/FAIB	0.00				2=1			
QC	**Memo**	0.00							
Quality Control			Y.A 09/08/11						
150	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00				(2) = 1			
Quality Control			09-08-12						

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 51222

August 11, 2009 9:59:42 AM

Item ID: D130-700-011 **Accept** **Setup Start** **Stop**

Revision ID: A

Item Name: Bearpaw

Start Date: 08/11/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 08/13/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Pick Kit	0.00							
Packaging						X1		MD 09/08/12	
Packaging	**Memo**	0.00							
170	QC4- 100% Inspect kits for completeness	0.00							
QC						set			
Quality Control	**Memo**	0.00				(10)	0		
180		0.00							
Packaging	Packaging								
Packaging	**Memo**	0.00							
Packaging	Identify and pack for shipping as per PPP D130-700-011 Rev A Location: _____								

=) 8/08/12

9/8/12 (10) SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 51222

August 11, 2009 9:59:42 AM

Item ID: D130-700-011 **Accept** **Setup Start** **Stop**

Revision ID: A

Item Name: Bearpaw

Start Date: 08/11/2009 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 08/13/2009 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00				_____	_____	_____	8508:12
Quality Control									

CMF 09-08-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 11, 2009 9:59:41 AM

Work Order ID: 51222

Parent Item: D130-700-011RevA

Parent Item Name: Bearpaw

Comments:

Start Date: 08/11/2009 **Required Date:** 08/13/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-12A		Purchased	No			170	Each	457.0000	4.0000			
Bolt												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	457	
111605	57	
111925	100	
112314	300	

4 x 111605 MD 09/08/12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-15A		Purchased	No			170	Each	1,006.000	8.0000			
Bolt												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	1006	
107737	8	
108077	1	
108868	7	
109148	18	
110399	8	
111295	964	

8 X 111295 MD 09/08/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 11, 2009 9:59:41 AM

Work Order ID: 51222

Parent Item: D130-700-011RevA

Parent Item Name: Bearpaw

Comments:

Start Date: 08/11/2009 **Required Date:** 08/13/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			170	Each	11,252.00	12.0000			
Washer												

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	11252	
102929	2	
105906	4	
107321	23	
107939	114	
108161	553	
108827	31	
109249	69	
110523	340	
111279	116	
111916	5000	
112314	5000	
16941	0	

12 V 111916 mo 09/08/12

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 11, 2009 9:59:41 AM

Work Order ID: 51222

Parent Item: D130-700-011RevA

Parent Item Name: Bearpaw

Comments:

Start Date: 08/11/2009 **Required Date:** 08/13/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2274RevF Radius Block		Manufactured	No			170	Each	496.0000	12.0000			

Warehouse Location	Loc Qty	Loc Code			
Main Warehouse					
ST	496				
22494	0				
23174	0				
36624	17				
38173	6				
42099	34				
43838	62				
47796	207		12 x	47796	MO 09/08/12
50227	170				

D2519RevD Clamp		Manufactured	No			170	Each	101.0000	4.0000			

Warehouse Location	Loc Qty	Loc Code			
Main Warehouse					
ST	101				
42407	17		4 x	42407	MO 09/08/12
43842	84				

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

August 11, 2009 9:59:41 AM

Work Order ID: 51222

Parent Item: D130-700-011RevA

Parent Item Name: Bearpaw

Comments:

Start Date: 08/11/2009 **Required Date:** 08/13/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2529RevE Washer		Manufactured	No			170	Each	265.0000	12.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	265	
45388	265	

12 X 45388 MD 09/08/12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3171-1RevA Angle		Manufactured	No			170	Each	19.0000	4.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	19	
38176	1	
43860	18	

1X 38176
3X 43860 MD 09/08/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

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August 11, 2009 9:59:41 AM

Work Order ID: 51222

Parent Item: D130-700-011RevA

Parent Item Name: Bearpaw

Comments:

Start Date: 08/11/2009 **Required Date:** 08/13/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4 Nut		Purchased	No			170	Each	9,911.000	12.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	9911	
107499	5	
110507	1869	
111827	5996	
112314	2000	
15924	0	
8182	41	

12 X 110507 MD 09/08/12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10 UHMW 1" Black		Purchased	No			120	sf	400.1010	7.1789			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	278.991	
110186	278.991	
Main Warehouse		
ST	121.11	
108762	18	
109186	5	
110520	8	
110721	24	
111354	66.11	

112186 112186 LB 9-8-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

August 11, 2009 9:59:41 AM

Work Order ID: 51222

Parent Item: D130-700-011RevA

Parent Item Name: Bearpaw

Comments:

Start Date: 08/11/2009 **Required Date:** 08/13/2009

Start Qty: 1.00 **Required Qty:** 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2182B060RevC Clamp Cushion		Manufactured	No			170	Each	0.0000	4.0000			

@ 6.00" Long

4X 45405 MD 07/08/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

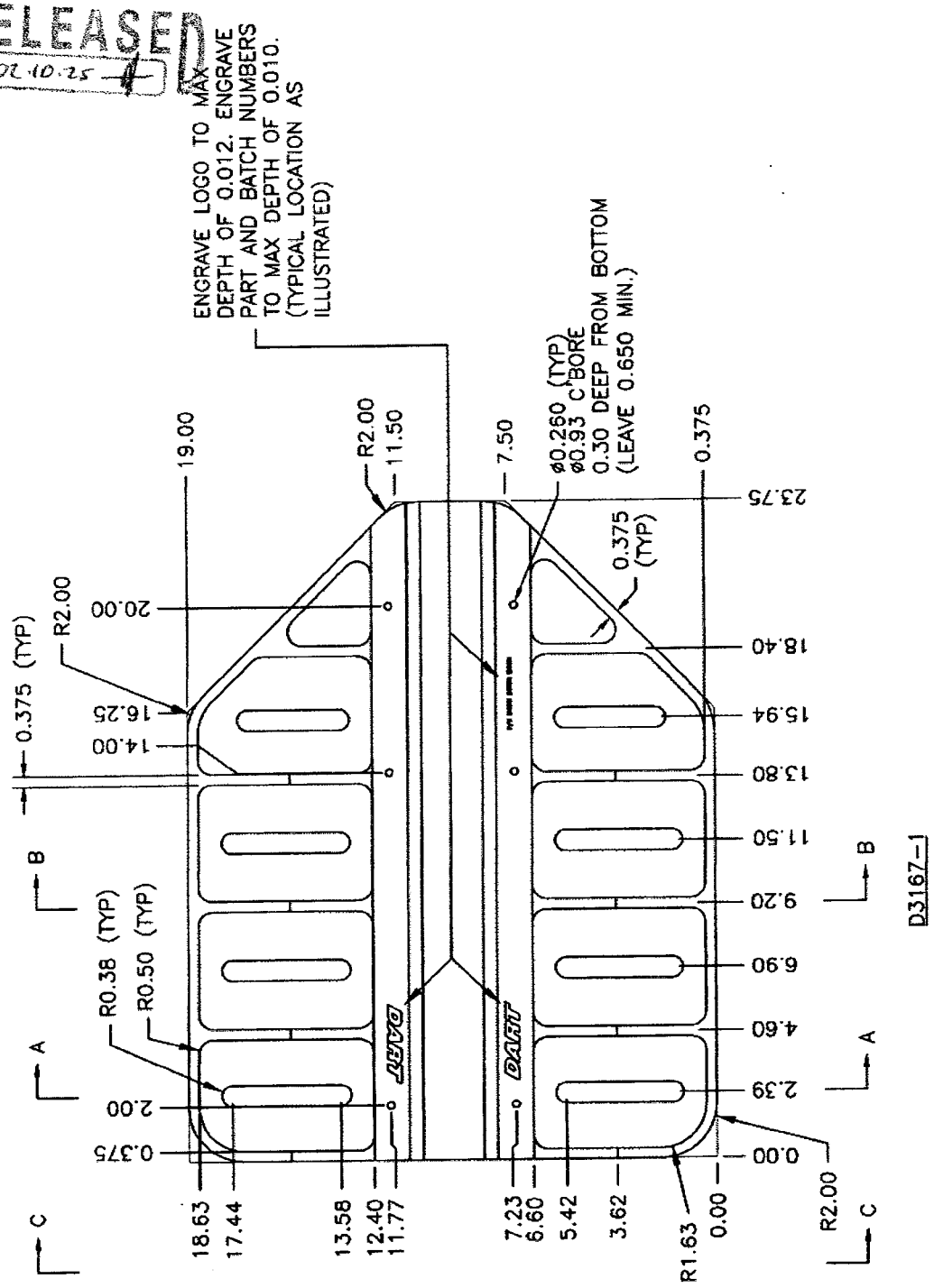
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO. D3167	REV. A SHEET 1 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:6

A	02.10.08	NEW ISSUE
A1	02.12.17	5.80 WAS 5.50 RF

RELEASED
02.10.25



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

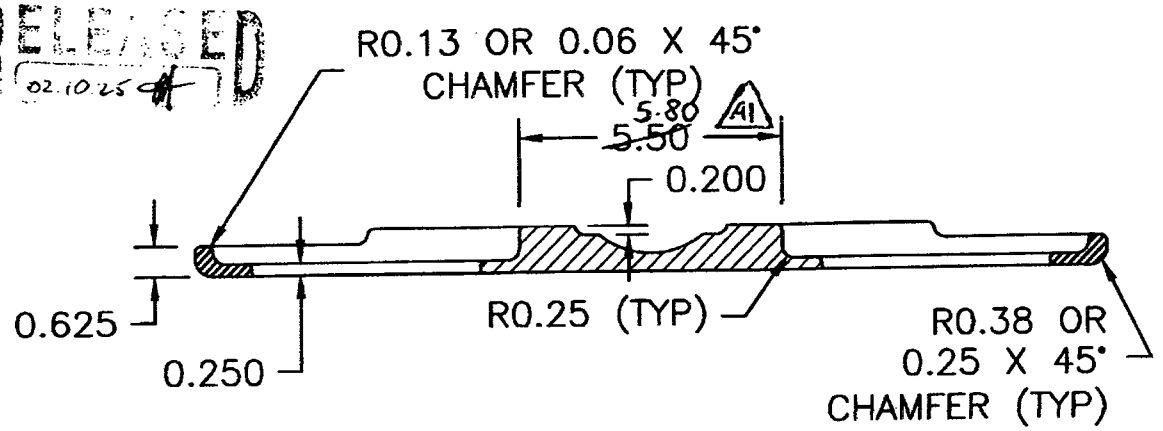
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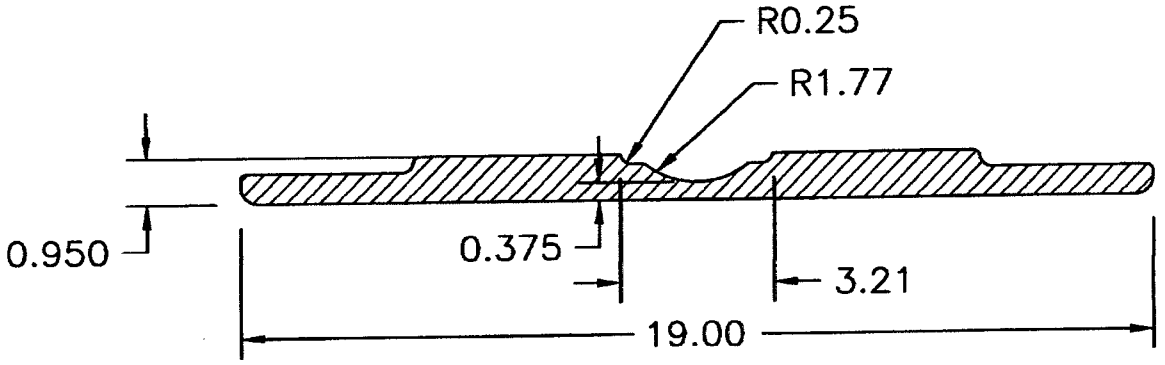
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

DA COPY ISSUED

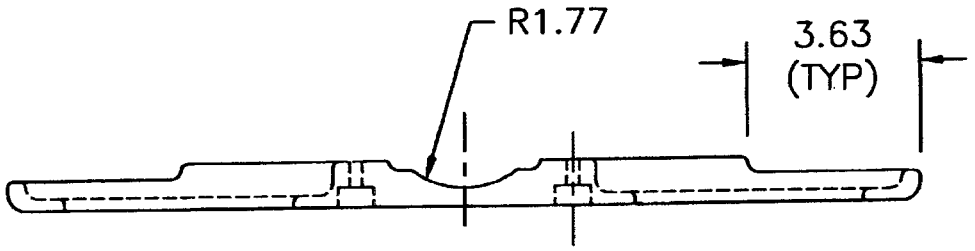
RELEASED
02.10.25



SECTION A–A



SECTION B–B



SECTION C–C

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DART AEROSPACE LTD	Work Order:	
Description: Bearpaw	Part Number:	D3167-1
Inspection Dwg: D3167 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	.063X45°	✓			
B	5.80	+/-0.030	5.796	✓			
C	0.25 x 45°	+/-0.030	0.253X45°	✓			
D	R0.25	+/-0.030	R0.250	✓			
E	0.200	+/-0.030	0.205	✓			
F	0.250	+/-0.010	0.245	✓			
G	0.625	+/-0.030	0.628	✓			
H	0.375	+/-0.010	0.373	✓			
I	0.950	+0.030/-0.010	0.962	✓			
J	3.21	+/-0.030	3.210	✓			
K	19.00	+/-0.030	19.00	✓			
L	Ø0.260	+0.005/-0.000	Ø0.260	✓			
M	Ø0.93	+/-0.030	Ø0.932	✓			
N	0.30	+0.030/-0.000	0.305	✓			
O	0.375	+/-0.030	0.378	✓			
P	7.23	+/-0.030	7.23	✓			
Q	4.54	+/-0.010	4.545	✓			
R	2.00	+/-0.030	2.001	✓			
S	12.000	+/-0.010	12.000	✓			
T	6.000	+/-0.010	6.000	✓			
U	23.75	+/-0.030	23.75	✓			

Measured by:	Y. A
Date:	09/08/11

Audited by:	
Date:	09.08.12

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change		Revised by	Approved
A	03.09.22	New Issue	P/O D130-700-011	KJ/RF	

32.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D130-700-011 Bearpaw Installation	12.5 lb 5.67 kg	0.0 in 0.0 m	0.0 lb-kg 0.0 m-kg	159.8 in 4.05 m	1998 in-lb 23.0 m-kg

32.4 PARTS LIST

Qty	Part Number	Description
X	D130-700-011	BEARPAW INSTALLATION
4	D2182B060	Rubber Cushion
12	D2274	Radius Block
12	D2529	Washer
4	D2519	Clamp
2	D3167-1	Bearpaw
4	D3171-1	Angle
4	AN4-12A	Bolt
8	AN4-15A	Bolt
12	AN960JD416	Washer
12	MS21042L4	Nut (or MS21042-4)

TC Accepted
DEC 1 8 2002

W10 51222

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Work Order ID 51222

August 11, 2009 9:59:42 AM

ASAP
ship thurs - Aug. 13th

Item ID: D130-700-011
Revision ID: A
Item Name: Bearpaw

Start Date: 08/11/2009 **Start Qty:** 1.00
Required Date: 08/13/2009 **Req'd Qty:** 1.00
Reference:

Accept **Setup** **Start** **Stop**

Cust Item ID:
Customer:

Approvals: **Process Plan:** [illegible] **Date:** 09-08-11 **Tooling:** **Date:** **Run** **Start** **Stop**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3167	Rev A1					2			
IIN-D130-700	Rev A								
100		0.00							
DC	DOCUMENT CONTROL								
Document Control	**Memo**	0.00							
	Photocopy bluefile and create labels per PPP D130-700-011CHG001								
	C20110812								
120		0.00							
Waterjet	FLOW WATER JET								
FLOW CNC Waterjet	**Memo**	0.00							
	Cut Blank as per File D3167-1_BLANK								

REFERENCE ONLY

B 9-8-11

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